

Date: Tuesday, 7/1/2008 2:33:22 PM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 BASKET BASE ASS'Y RH
 Job Number : 40180B
 Estimate Number : 11543
 P.O. Number :
 This Issue : 7/1/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3053042
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D3053 UNDER REVIEW
 Previous Run : 37413B Drawing Revision : A
 Material :
 Due Date : 7/30/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JP 08.07.01
 Comment : Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/SK
 J/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)
 304 SQ Tube.75x.75x.065W

1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: M108250

2-Drill holes in D3053-3 as per dwg D3053

SAD 08/07/08

①

2.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Qty. 5 D3166-1

Batch: B410090

SAD

08/07/08

①

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 5 D2235-3 FROM D3166-1 using DT8365

2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

SAD 08/07/15

SAD 08/07/08

①

4.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B 37541

SAD 08/07/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 40180B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge plate

B39334

JS 08/07/10

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

B39046

JS 08/07/10

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number Description Batch

48sq.ft M304EX0.75-16F

Expanded Metal

Batch

M108434 (34.4)

M108152 C16

SAD 08/07/14

(1)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

SAD 08/07/14 (1)

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

JS 08/07/15

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PS 08-0-16 (1)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/07/16 (x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 40180B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

12.0

POWDER COATING

POWDER COATING



M107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1ST COAT

2ND COAT

START TIME:

1:31pm

START TIME

2:40pm

OVEN TEMPERATURE:

400F

OVEN TEMP

400F

FINISH TIME:

2:00pm

FINISH TIME

3:15pm

08-02-07

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/L 08/07/18 (10)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

08/07/21 @

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/22

Job Completion



MF 08-07-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

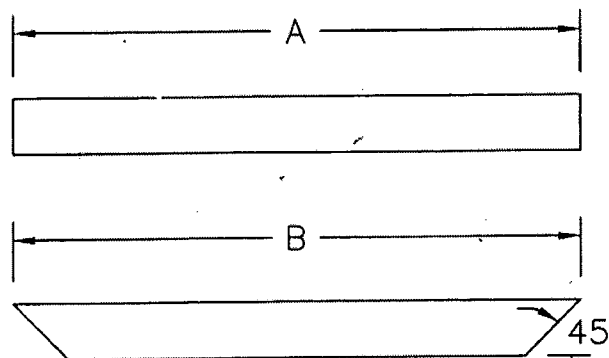


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN RT | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3053 | REV. A SHEET 1 OF 3 |
| DATE 01.11.01 | | TITLE BASKET BASE ASSEMBLY (212) | SCALE NTS |
| A | 01.11.01 | NEW ISSUE | |

RELEASED
01.12.20

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|---------------|
| D3053-1 | 2 | — | 96.00 | RIB |
| D3053-3 | 2 | — | 25.50 | RIB |
| D3053-5 | 6 | 23.73 | — | RIB |
| D3053-7 | 3 | 25.31 | — | RIB |
| D3053-9 | 3 | 19.48 | — | RIB |
| D2327-3 | 2 | N/A | N/A | BUSHING |
| D2581 | 2 | N/A | N/A | MOUNTING BRKT |
| D2232-3 | 2 | N/A | N/A | HINGE PLATE |
| D2235-3 | 5 | N/A | N/A | RIB |



OK 08.07.01
UNDER REVIEW
07.02.05 PH

TUBING TO BE
CHANGED TO 0.065
WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40180B

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

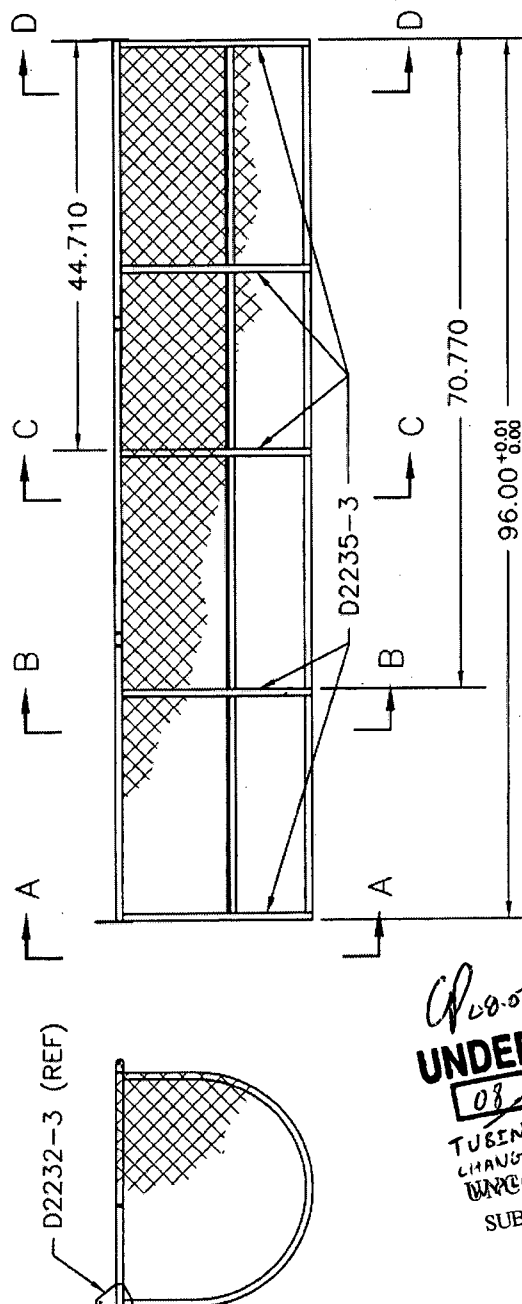
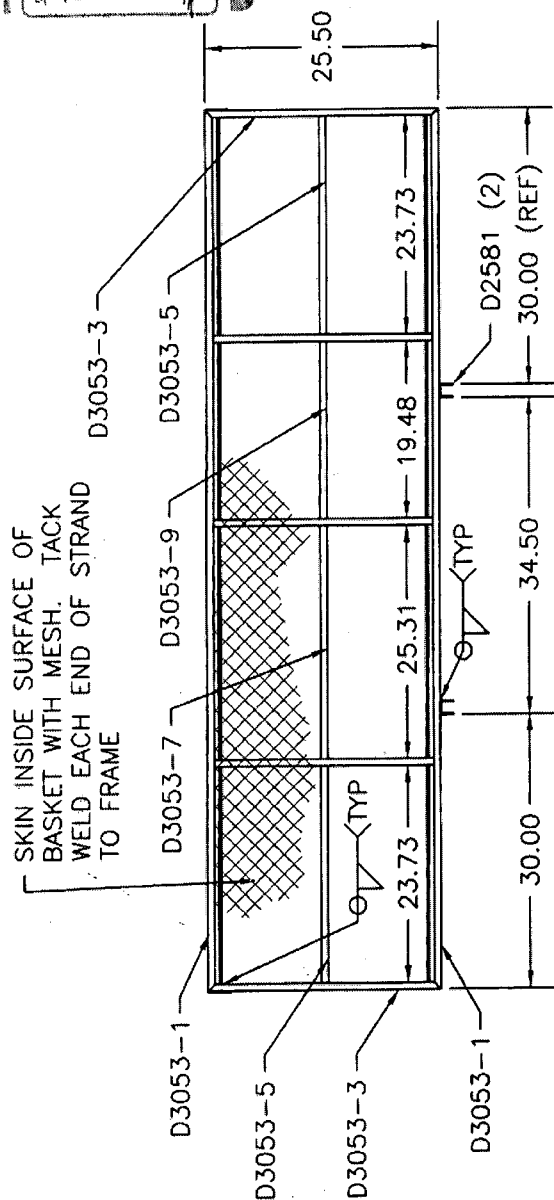
Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



| | | | |
|------------------------|-------------------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3053 | REV. A SHEET 2 OF 3 |
| DATE 01.11.01 | TITLE BASKET BASE ASSEMBLY (212) | | SCALE 1:20 |

RELEASED
01.12.20



D2232-3 (REF)

D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

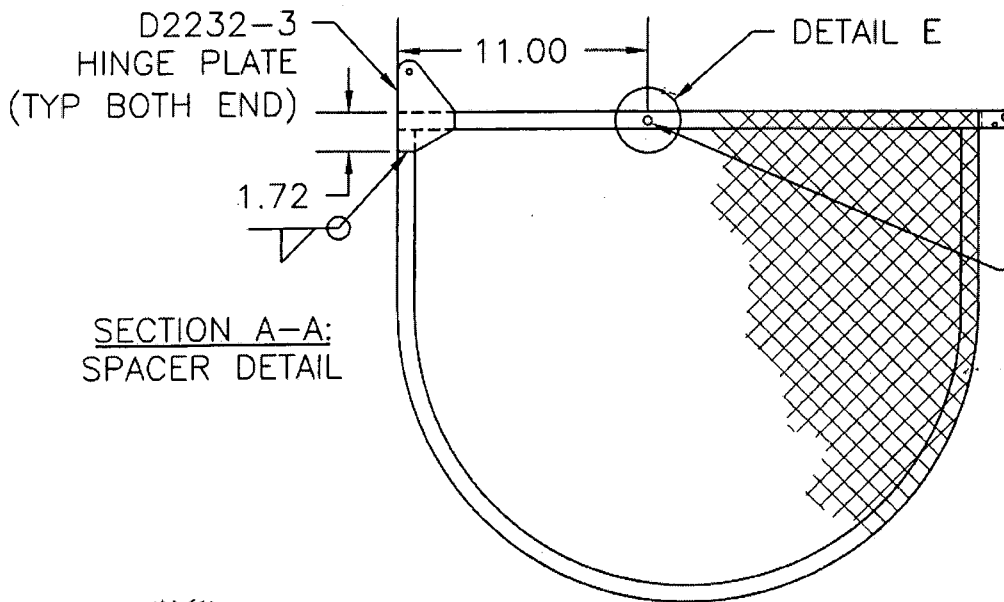
CP 08.07.01
UNDER REVIEW
08/08/01
RETURN TO
TUBING TO BE
CHANGED TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40180 B

Copyright © 2001 by DART AEROSPACE LTD

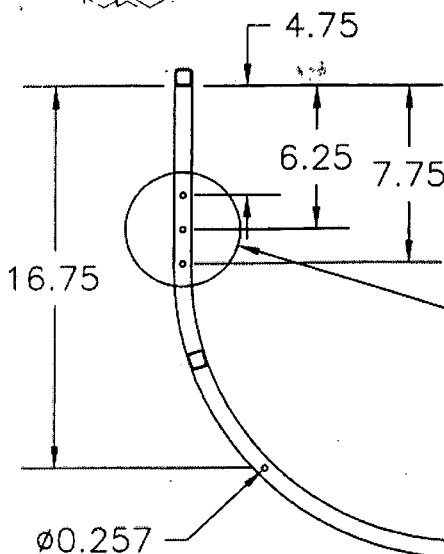
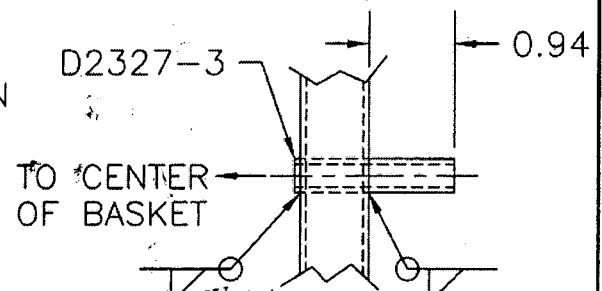
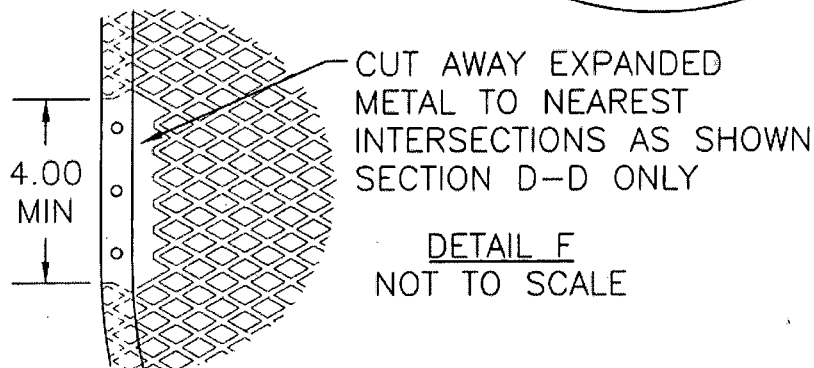
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

| | | | |
|------------------|-------------------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED A | APPROVED H | DRAWING NO. D3053 | REV. A SHEET 3 OF 3 |
| DATE 01.11.01 | TITLE BASKET BASE ASSEMBLY (212) | | SCALE 1:8 |

**RELEASED**
01.12.20 #

DRILL 3/8 HOLE
AND INSTALL
D2327-3 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40180B
11.55
DETAIL E
08.02.05
TUBING TO BE
CHANGED TO 0.065
WALL

SECTION B-B,
SECTION C-C AND
SECTION D-D:
RIB DETAIL

DRILL 0.257 DIA HOLES
USE DRILL JIG T2489DJ
(SEE DETAIL F)

EXPANDED METAL

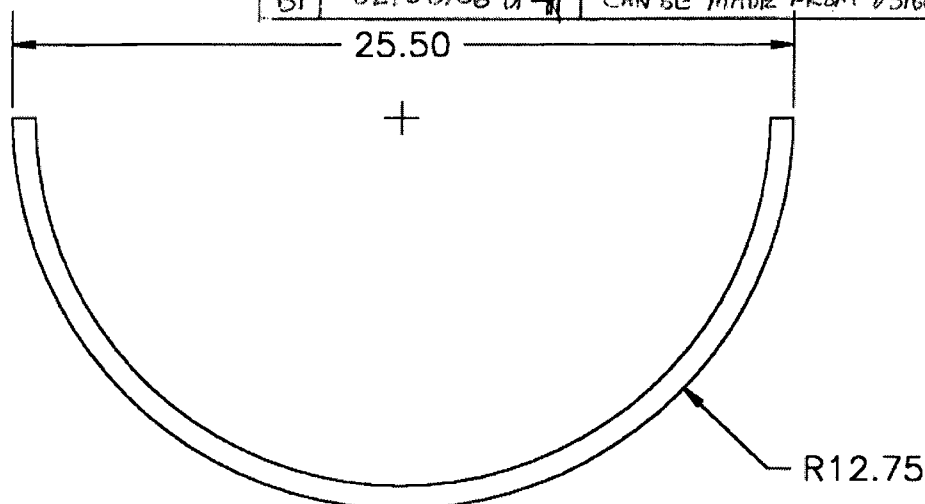
Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

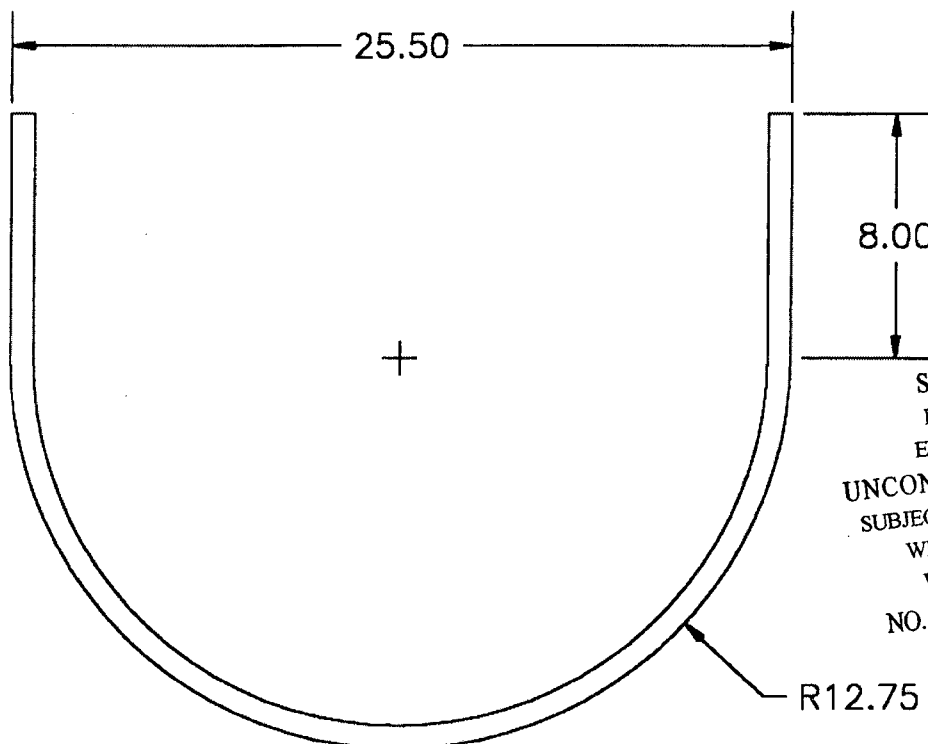


| | | | |
|-----------------------|------------------------|--|------------------------|
| DESIGN B WILLIAMS | DRAWN BY B WILLIAMS | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>BW</i> | APPROVED <i>BW</i> | DRAWING NO. D2235 | REV. B SHEET 1 OF 1 |
| DATE 94:12:16 | | TITLE BASKET RIBS SCALE | |
| BI 02.08.06 <i>UP</i> | | CAN BE MADE FROM D3166-1 | |

RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *BI*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.